



Work Order ID 56589

March 2, 2010 7:43:13 AM



Page 1

Item ID: D3728-1

Accept



Setup Start



Revision ID:

Item Name: Step Bracket

Stop



Start Date: 3/02/10 Start Qty: 10.00



Cust Item ID:

Required Date: 3/02/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3728	Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

HB 10-3-2

FLOW CNC Waterjet

1-Cut as per Dwg D3728 || Dwg Rev: B || Prog Rev: B || 2-
Deburr if necessary

(12)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

HB 10-3-2

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

Sub 10308

(412)

QC

Memo

0.00

Quality Control

Work Order ID 56589

March 2, 2010 7:43:13 AM

Page 2

Item ID: D3728-1

Accept



Setup Start



Revision ID:

Item Name: Step Bracket

Stop



Start Date: 3/02/10 Start Qty: 10.00



Cust Item ID:

Required Date: 3/02/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

Small Fab

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Small Fab

Small Fab

Memo

0.00

1-open holes to finish size as per dwg D3728
 2- Deburr if necessary
 3- grind water jet marks all around bracket smooth
 ****do not grind inside where step extrusion goes****

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

150



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 56589

March 2, 2010 7:43:14 AM



Page 3

Item ID: D3728-1

Accept



Setup Start



Revision ID:

Item Name: Step Bracket

Stop



Start Date: 3/02/10 Start Qty: 10.00



Cust Item ID:

Required Date: 3/02/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

=7 m-f 10/03/02

170



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

SAD

10-03-02

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/03 JJ

MF
10-3-2

Picklist Print

March 2, 2010 7:43:12 AM

Page 1

Work Order ID: 56589



Parent Item: D3728-1



Parent Item Name: Step Bracket

Start Date: 3/02/10

Required Date: 3/02/10

Comments: IPP Rev:A 08-01-30 new issue DD verified by:EC
IPP Rev:B 08-02-26 ECN 1140p DD verified by:
IPP Rev:C 08-03-19 chg to revB ecn1158 DD verified by:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ M6061T6B0.250X06.00 0	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of f	Qty on 50.7196	Remaining 13.5179	Qty 16.5	Date	Status
--	-------------	-------------------	-----------	---------	------	--------------	--------------	-------------------	----------------------	-------------	------	--------



6061-T6 Bar .250 x 6.00



RP 10-3-2

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	50.7196	
108462	2	
10925	3	
113181	45.7196	113181

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	56589
Description: ST	Part Number:	D 3728-1
Inspection Dwg:D 3728-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

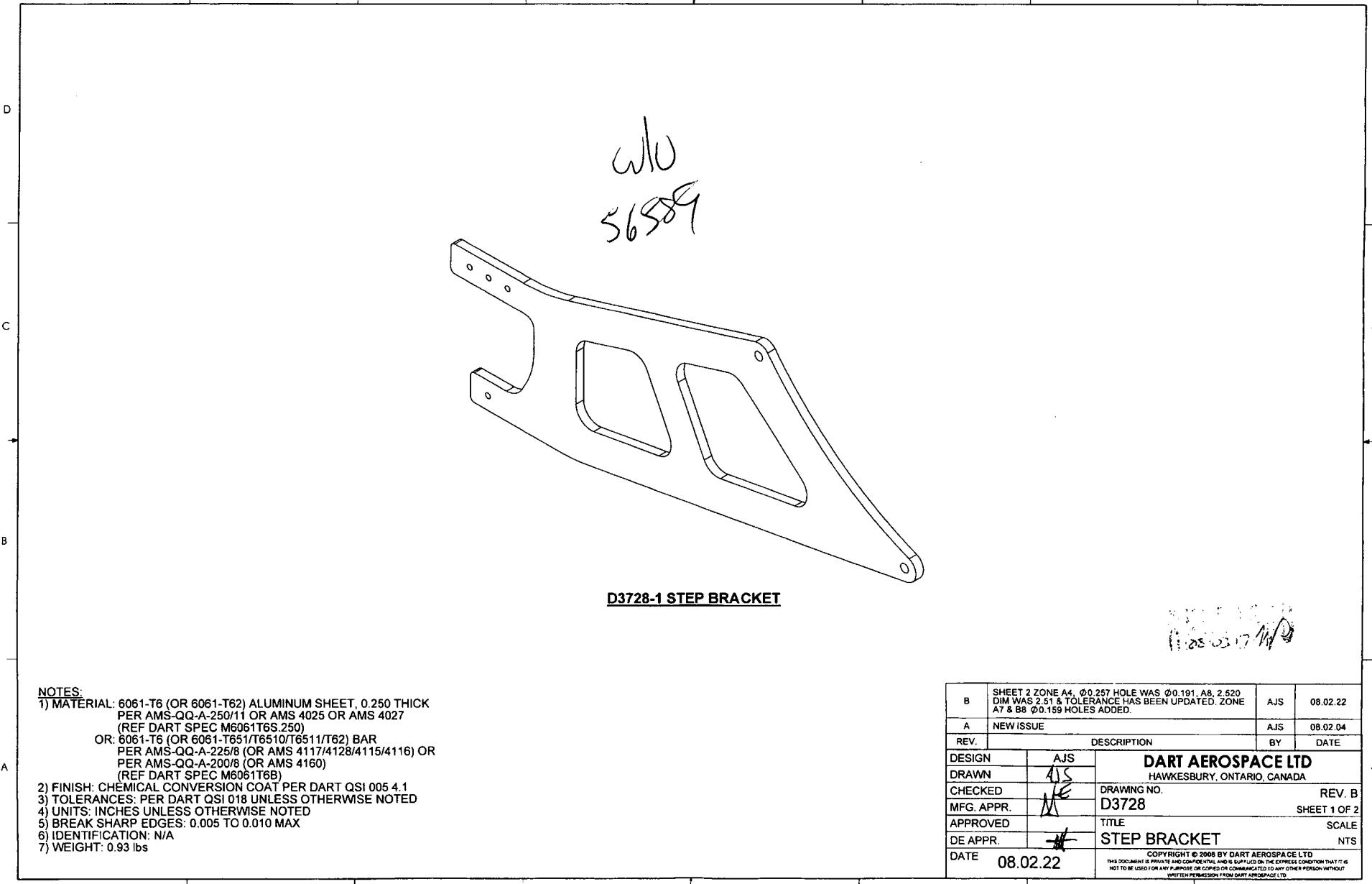
Measured by:	<u>BS</u>
Date:	10-3-2

Audited by:	S
Date:	colorz / 02

Prototype Approval:	N/A
Date:	N/A

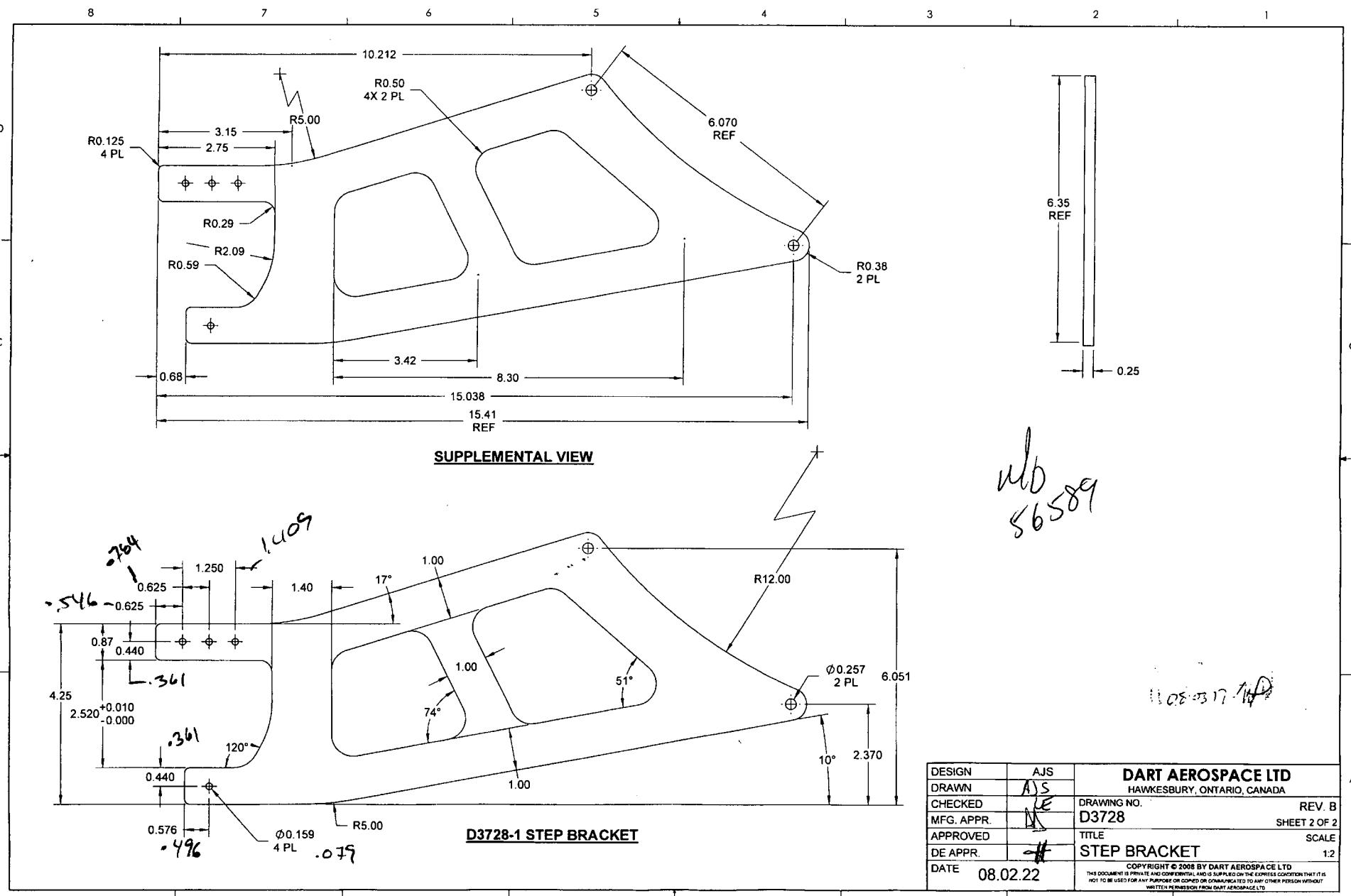
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

A B C D A B C D



DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	LE	DRAWING NO.	REV. B	
MFG. APPR.	DL	D3728	SHEET 2 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.	#	STEP BRACKET	1:2	
DATE	08.02.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PROPRIETARY INFORMATION AND IS SUPPLIED UNDER THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT				